

Work Order ID 77026

77026

Page 1

Thursday, November 24, 2011 3:23:58 PM

Item ID: D350-589-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 11/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
INN-D350-589	E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

Sizaloy

CK Per MWS 11/12/06

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

Per MWS 11/12/06 (2)

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

Sizaloy

(Y2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 11/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

Rev f
FG 122

12/1/11/45/2

CK 12/01/05

mf
12-01-03

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 77026

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	6			
<i>S-2</i> *AN960.ID10*									**	1198 37			
Washer													
D2237		Manufactured	No			105	Each	26.0000	3	6			
<i>S-4</i> *D2237*									**	7787224			
Striker Plate												11/24/11	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST009	26							
					66139	2							
					73702	24				73702 40			
D2583		Manufactured	No			105	Each	7.0000	3	6			
<i>S-2</i> *D2583*									**	76074			
Latch Bracket					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST017	7							
					74073	7							
D2585		Manufactured	No			105	Each	65.0000	3	6			
<i>S-2</i> *D2585*									**				
Mounting Channel					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST017	65							
					73297	2							
					74488	63				74488			

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2586 Manufactured No

105

Each

72.0000

3

6

**

D2586

Door Latch

Location

Loc Qty

Loc Code

ST204

72

73296

32

74489

40

105

Each

28.0000

1

**

D2587

Manufactured No

D2587

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

28

74522

28

105

Each

52.0000

1

**

D2589

Manufactured No

D2589

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

52

58194

52

105

Each

2,394.000

6

**

MS20470AD4-5

Purchased No

MS20470AD4-5

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2394

116893

74

118405

2320

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Shop Packet Print

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

MS2104213

Purchased

No

105

Each

7,996.000

**

MS2104213

Nut

Location

Loc Qty

Loc Code

ST300

213

117441

16

117885

35

118451

5

118927

157

ST516

5994

119017

5994

ST518

1789

119075

1789

MS27039-1-15

Purchased

No

105

Each

148.0000

**

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

ST291

148

118093

25

118574

23

119736

100

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Shop Packet Print

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REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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